

Date: Thursday, 5/4/2006 11:09:51 AM  
 User: Kim Johnston

## Process Sheet

|  |                                 |
|--|---------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BEARING ASSEMBLY |
| Job Number : 26929                             |                                 |
| Estimate Number : 10716                        |                                 |
| P.O. Number : <b>NIA</b>                       | Part Number : D3121241          |
| This Issue : 5/4/2006 S.O. No. : <b>NIA</b>    | Drawing Number : D3121 REV C2   |
| Prsht Rev. : NC                                | Project Number : N/A            |
| First Issue : <b>NIA</b> Type : MACHINED PARTS | Drawing Revision : C2           |
| Previous Run : 25561                           | Material : <b>NIA</b>           |
| Written By : <u>SEE COMMENT BELOW</u>          | Due Date : 5/18/2006            |
| Checked & Approved By : <u>06.05.05</u>        | Qty: <u>116</u> Um: <u>Each</u> |
| Comment : Est Rev:A 04.02.18 New issue KJ/DS   |                                 |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |               |                        |
|-----|---------------|------------------------|
| 1.0 | MDELRLNR12500 | DELRIN ROUND BAR 1.25" |
|-----|---------------|------------------------|



Comment: Qty.: 0.0546 f(s)/Unit Total : 0.4368 f(s)  
 Material: Ø1.25 Delrin Rod  
 (M-DELRIN-R1.2500) Identify as D3121-25  
 Batch: M101078 65"

MS 06/06/15

|     |          |                          |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



Comment: HARDINGE CNC LATHE SMALL

1-Turn D3121-25 Cap as per Folio FA387

2-Deburr

MS 06/06/15

116

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/06/15

116

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

MS 06/06/15 x 116

|     |         |         |
|-----|---------|---------|
| 5.0 | D312123 | Bearing |
|-----|---------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-23

Bearing 26936B27645100

MS 06/06/15 1

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 11:09:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 26929

Part Number: D3121241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

*ml 06/06/21*

*Qty 101*

*PO*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*06/06/26*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST409*

*06/06/26 (101)*

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/06/28*

Job Completion



*06-06-27*

*3X D3121*

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☒ DQA: ☒ Date: 06/06/28  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR)  |                             |  |                |                                |                             |                                |
|------|------|---|-----------------------------|--|----------------|--------------------------------|-----------------------------|--------------------------------|
| DATE | STEP | Description of NC<br>Section A  | Corrective Action Section B |  |                | Verification<br>Section C      | Approval<br>Chief Eng       | Approval<br>QC Inspector       |
|      |      |   | Initial<br>Chief Eng        | Action Description<br>Chief Eng                              | Sign &<br>Date |                                |                             |                                |
|      | 6.0  | 3x D3121-25 caps damaged<br>When installing bearings,<br>along inside diameter. | <i>[Signature]</i><br>05/47 | Scrap: destroy - 25<br>caps: replace                         |                | <i>[Signature]</i><br>06-06-26 | <i>[Signature]</i><br>05/22 | <i>[Signature]</i><br>06-06-21 |
|      |      |   |                             | Re-do 3 x D3121-241 m/f<br>stock 12 x D3121-25<br>u Adj 1608 | 06-06-23       |                                |                             |                                |
|      |      |   |                             |  |                |                                |                             |                                |

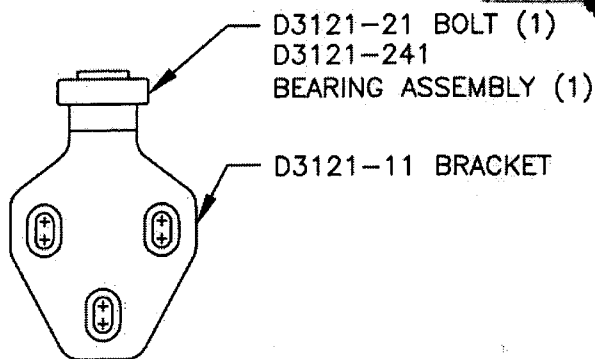
NOTE: Date & initial all entries





|                  |          |   |                         |
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| CHECKED          | APPROVED | DRAWING NO.<br>D3121  | REV. C<br>SHEET 1 OF 10 |
| DATE<br>04.02.17 |          | TITLE<br>BRACKET ASSEMBLY   | SCALE<br>1:2            |
| A                | 02.04.15 | NEW ISSUE   |                         |
| B                | 03.01.16 | ADD RIDGES; ADD MAT'L PROP; FIX P/N<br>ADD -141/-143/-144/-145/-146 |                         |
| C                | 04.02.17 | ADD CLEARANCE; USE -241 BEARING                                     |                         |
| C1               | 04.03.26 | 3.97 WAS 4.00; 6.11 WAS 6.14  |                         |
| C2               | 04.04.26 | 0.230 WAS 0.238   |                         |

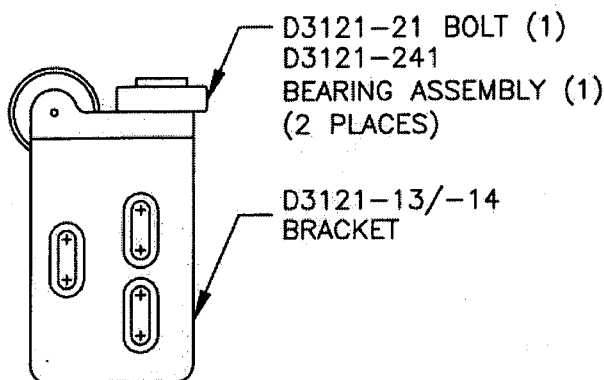
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D3121-21 BOLT (1)  
D3121-241  
BEARING ASSEMBLY (1)

D3121-11 BRACKET

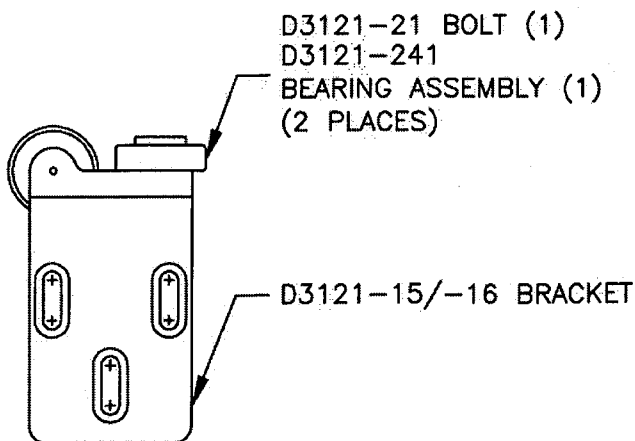
**D3121-041 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-33)



D3121-21 BOLT (1)  
D3121-241  
BEARING ASSEMBLY (1)  
(2 PLACES)

D3121-13/-14  
BRACKET

**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-21 BOLT (1)  
D3121-241  
BEARING ASSEMBLY (1)  
(2 PLACES)

D3121-15/-16 BRACKET

**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-35/-36)

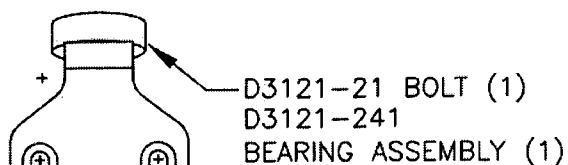
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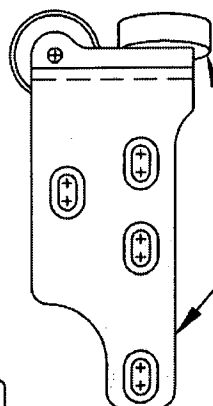
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| DATE<br>04.02.17 |                | TITLE<br>BRACKET ASSEMBLY                         | SCALE<br>1:2            |



D3121-21 BOLT (1)  
D3121-241  
BEARING ASSEMBLY (1)

D3121-111 BRACKET

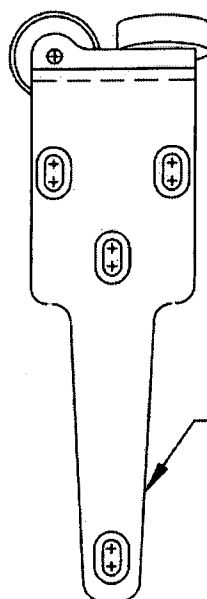
**D3121-141 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23001-01)



D3121-21 BOLT (1)  
D3121-241 BEARING ASSEMBLY (1)  
(2 PLACES)

D3121-113/-114 BRACKET

**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)**  
**BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-21 BOLT (1)  
D3121-241 BEARING ASSEMBLY (1)  
(2 PLACES)

D3121-115/-116  
BRACKET

**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)**  
**BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-05/-06)

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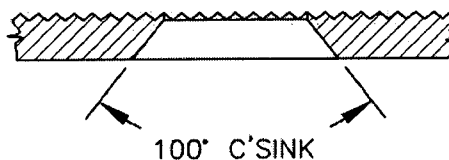
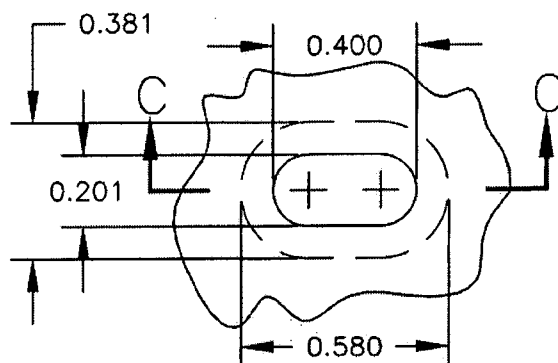
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| DATE<br>04.02.17 |                | TITLE<br>BRACKET ASSEMBLY                         | SCALE<br>1:1            |

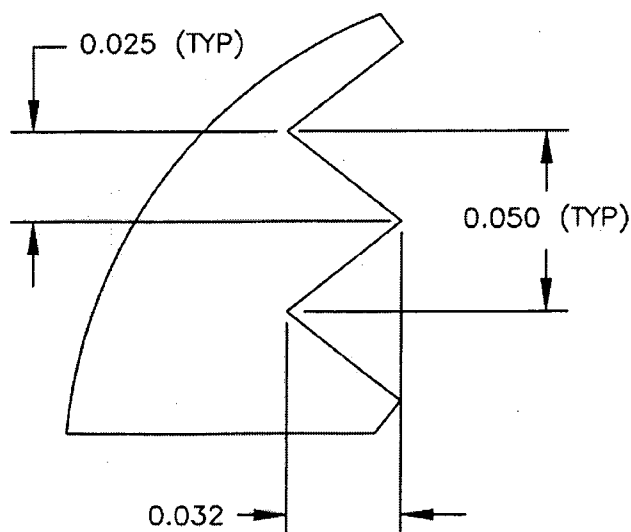
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**DETAIL A:**  
**SLOT DETAIL**  
SCALE 2:1  
VIEW ROTATED



**SECTION  
C-C**

**DETAIL B:**  
**RIDGE DETAIL**  
PARTIAL SECTION  
SCALE 1:20



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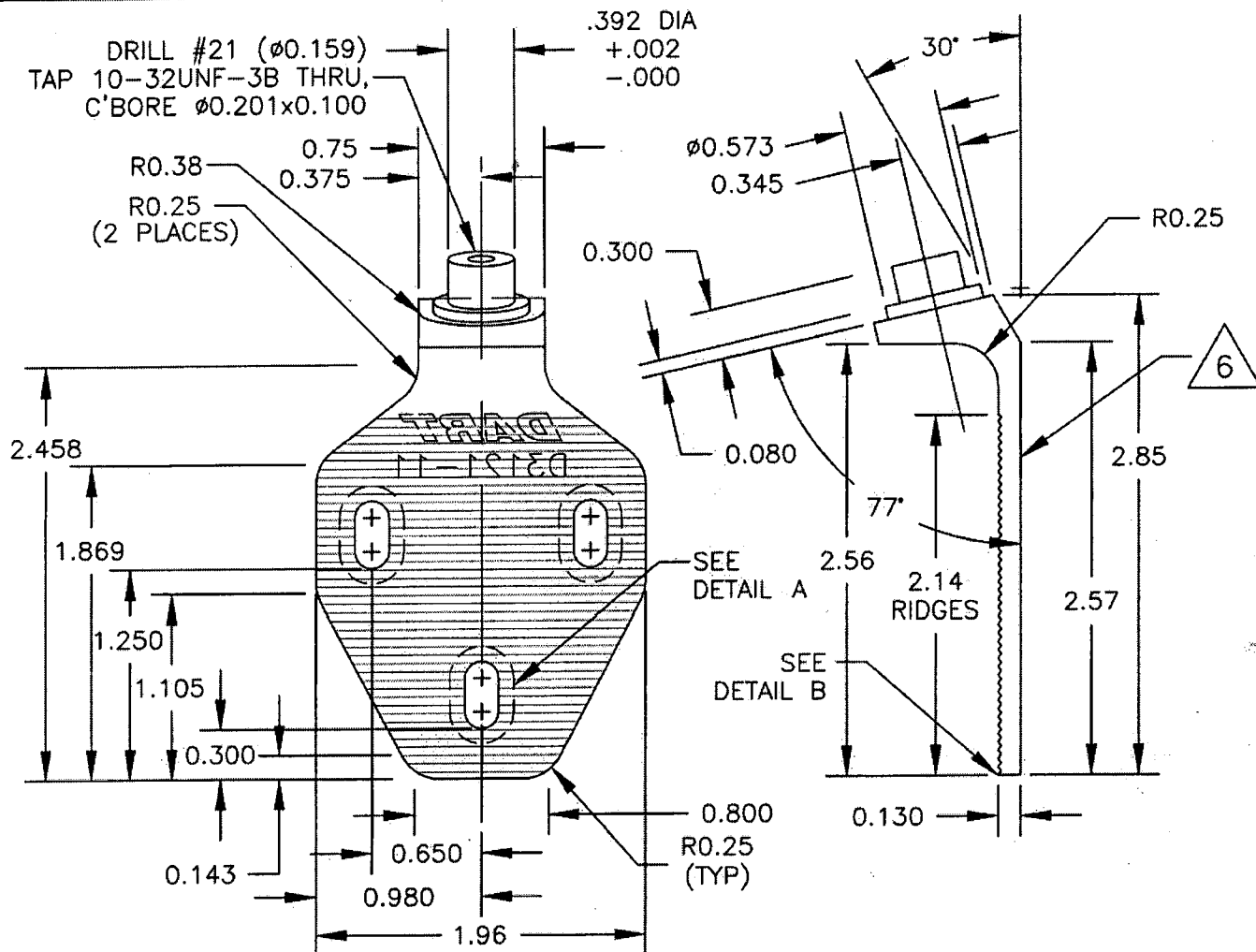
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| DATE<br>04.02.17 | TITLE<br>BRACKET ASSEMBLY |   | SCALE<br>1:1            |



#### D3121-11 BRACKET

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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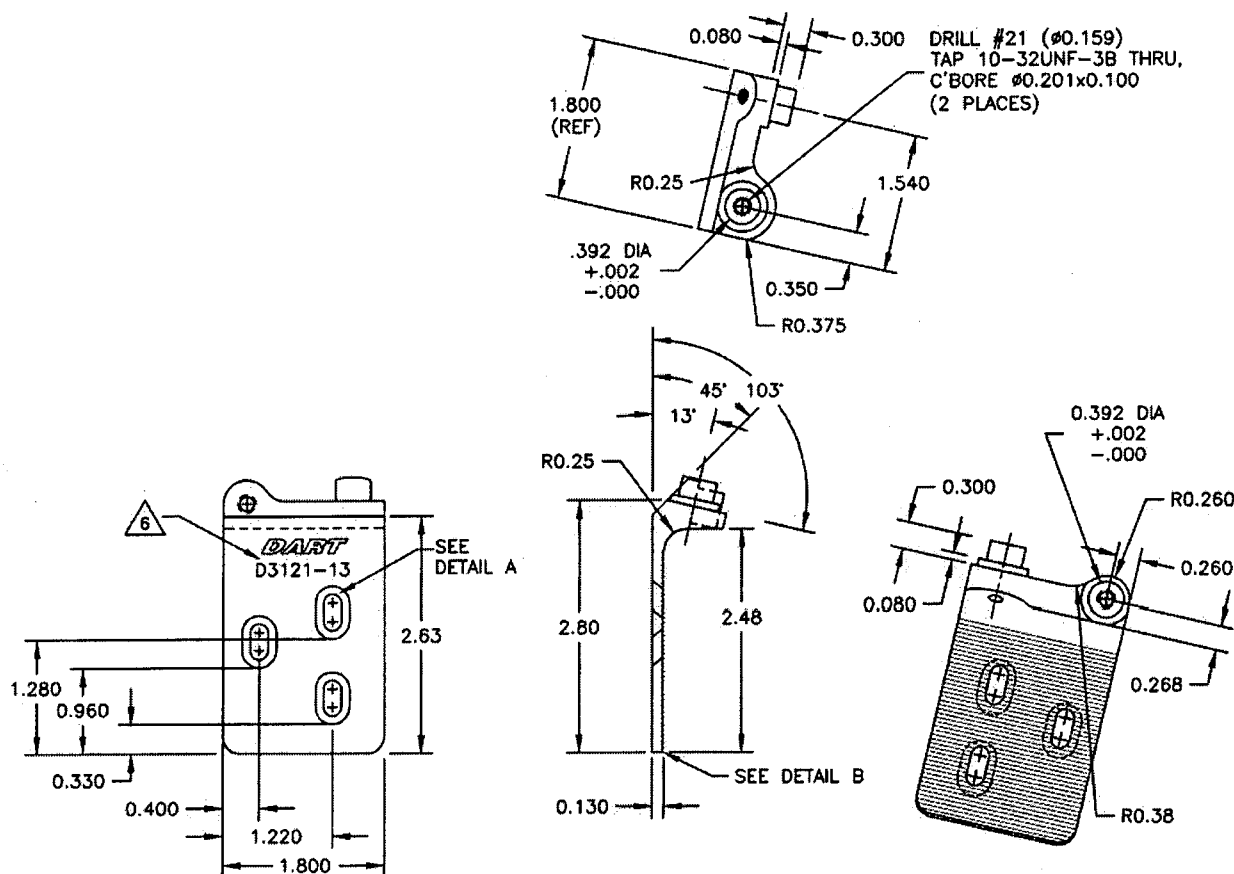
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| DATE<br>04.02.18 |               | TITLE<br>BRACKET ASSEMBLY                         | SCALE<br>1:2            |



**D3121-13 BRACKET (SHOWN)**  
**D3121-14 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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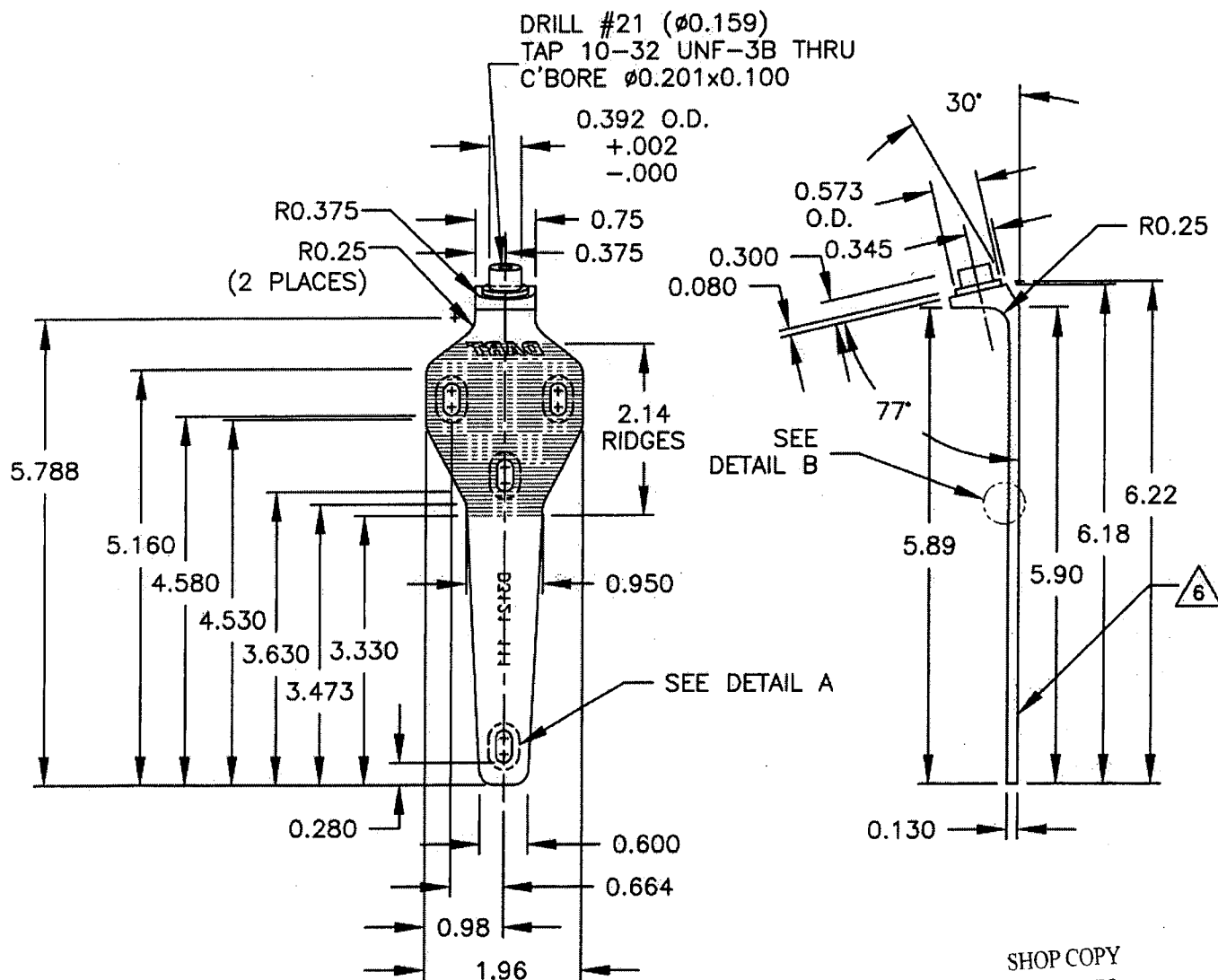
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| DATE<br>04.02.18              |                                | TITLE<br>BRACKET ASSEMBLY                         | SCALE<br>1:2            |



#### D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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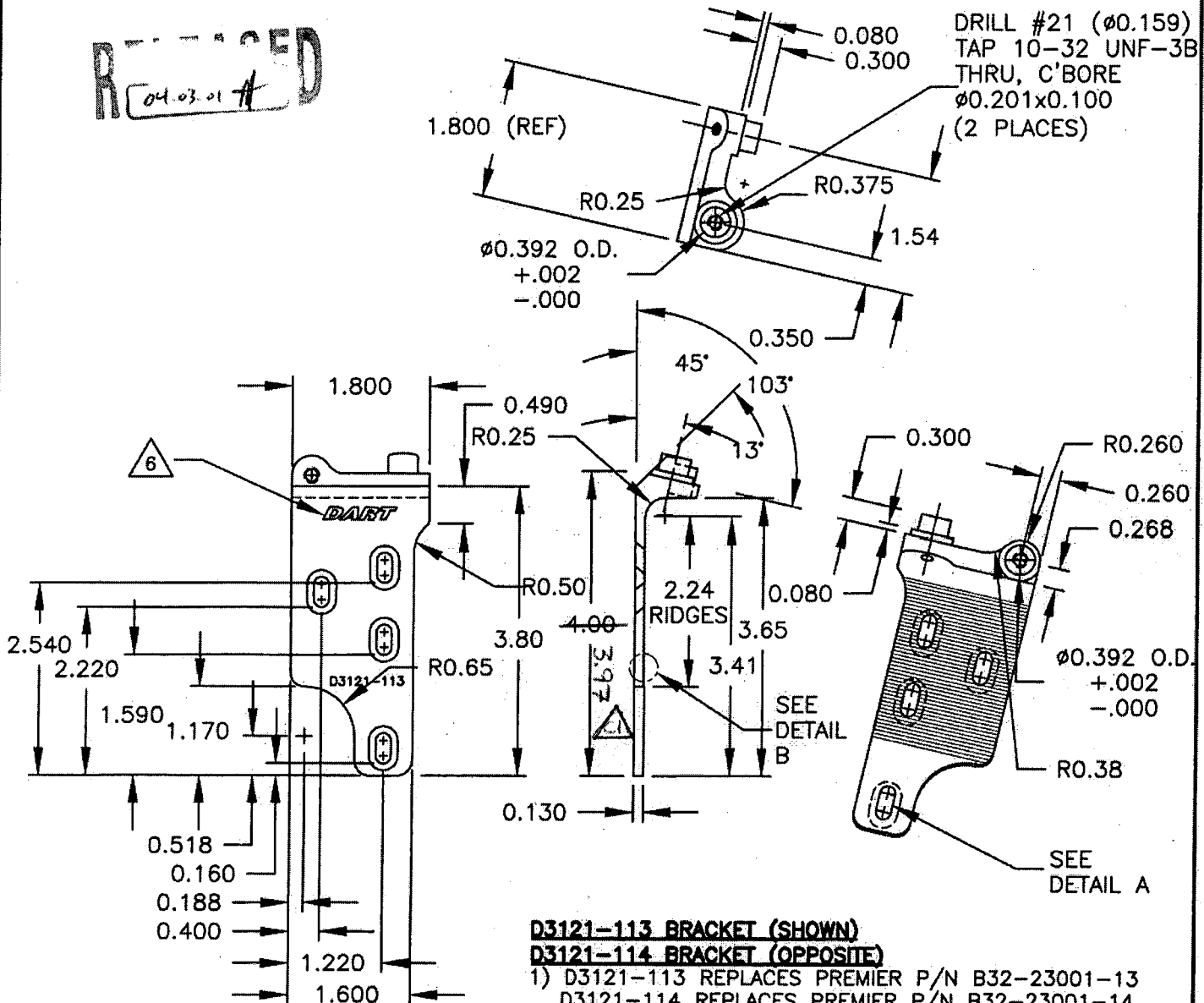
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| DATE<br>04.02.18           | TITLE<br>BRACKET ASSEMBLY   |  | SCALE<br>1:2            |

**RECEIVED**  
04.03.01 *[Signature]*



**D3121-113 BRACKET (SHOWN)**

**D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13  
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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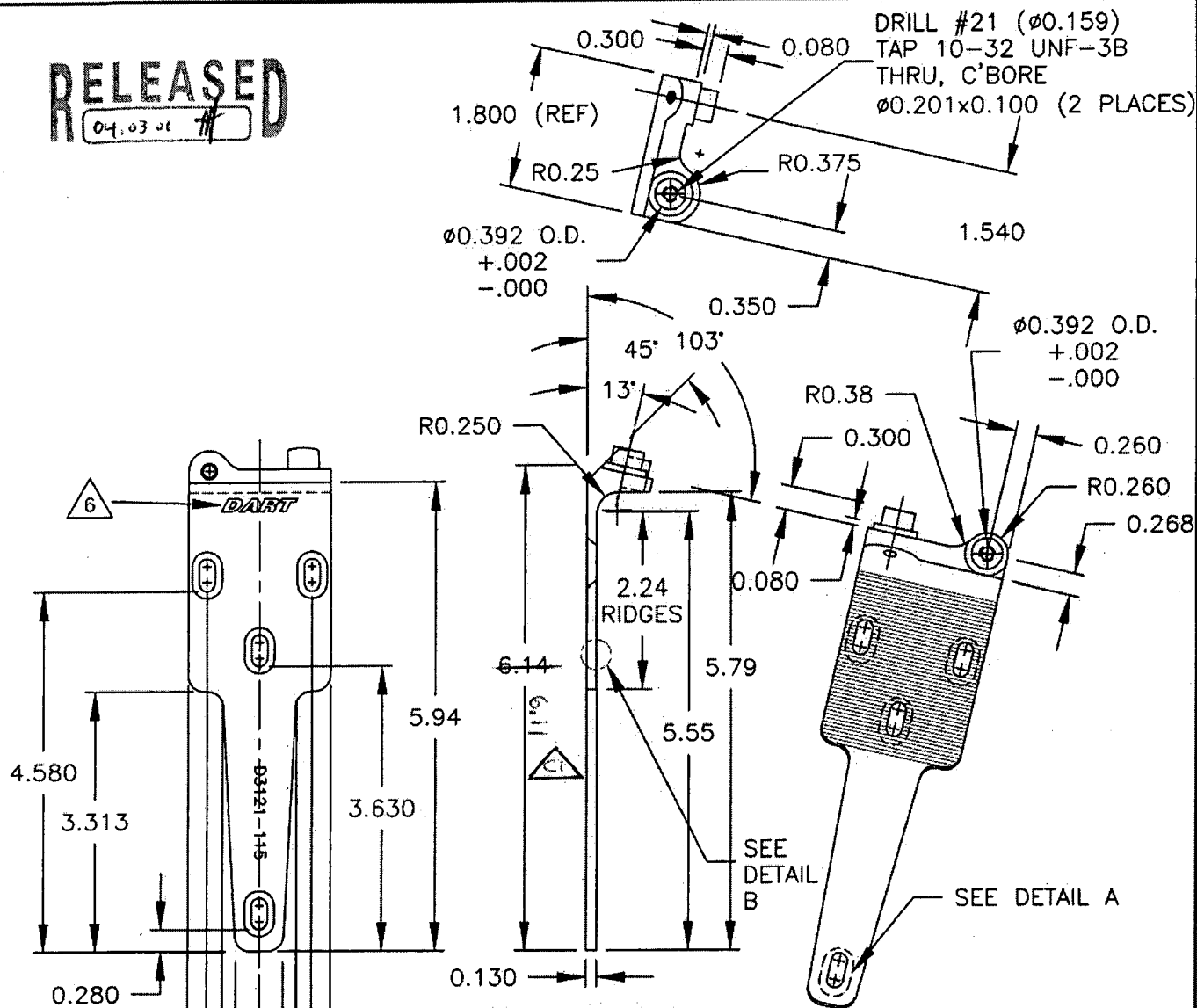
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NO. 26929



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| CHECKED<br>#     | APPROVED<br># | DRAWING NO.<br>D3121                              | REV. C<br>SHEET 9 OF 10 |
| DATE<br>04.02.18 |               | TITLE<br>BRACKET ASSEMBLY                         | SCALE<br>1:2            |

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**D3121-115 BRACKET (SHOWN)**

**D3121-116 BRACKET (OPPOSITE)**

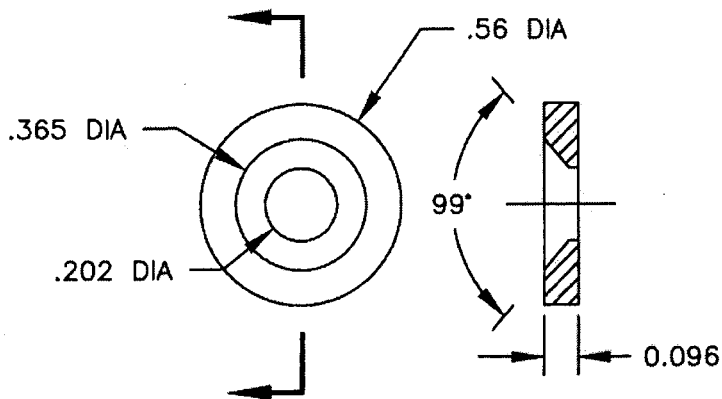
- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15 STOP COPY  
D3121-116 REPLACES PREMIER P/N B32-23001-16 RETURN TO
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 1500 ksi  
MIN YIELD TENSILE STRENGTH = 1000 ksi  
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WORK ORDER  
26929
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN NO.
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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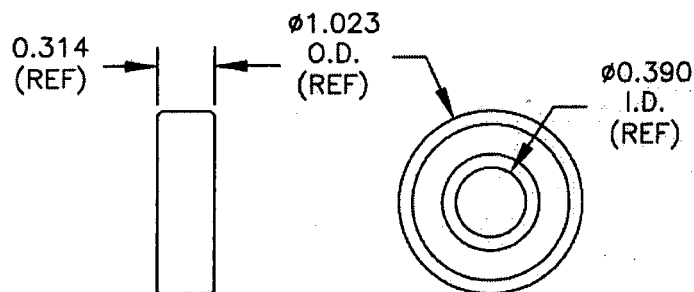
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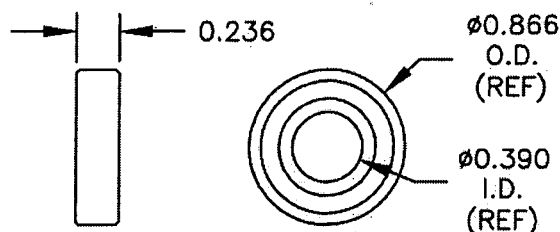
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| CHECKED<br>#     | APPROVED<br>#             | DRAWING NO.<br>D3121                                     | REV. C<br>SHEET 10 OF 10 |
| DATE<br>04.02.17 | TITLE<br>BRACKET ASSEMBLY |  | SCALE<br>1:1             |

**D3121-17 WASHER (SCALE 2:1)**

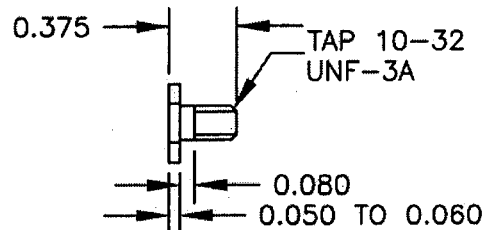
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

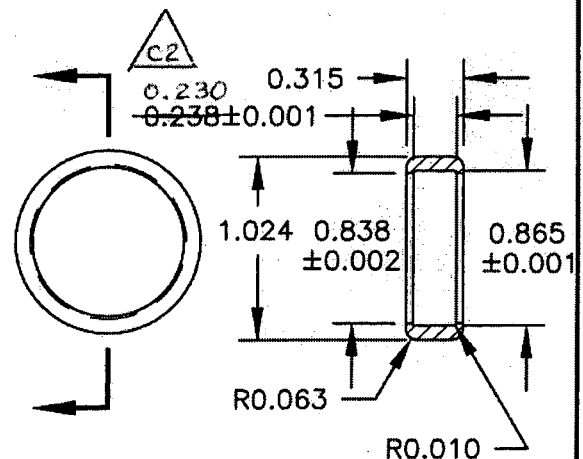
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

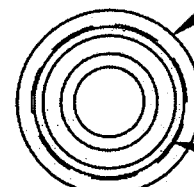
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, 1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
04.03.01 91



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D3121-25  
CAP  
WITHOUT NOTICE  
WORK ORDER  
NO. 26929  
D3121-23  
BEARING

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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